

Work Order ID 121488

121488

Page 1

September-16-14 12:37:49 PM

Item ID: D4297-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 6/26/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *V* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4297	C

105 0.00

105

Purchasing Memo 0.00

Purchasing ISSUE PO 25836
 Cut Blank per D2432 file

CL 14/10/18 2

115 Receive & Inspect for Damage & Mat'l Certs 0.00

115

Packaging Memo 0.00

Packaging P 14/10/18 (2)

125 QC6- Inspect dimensions to drawing 0.00

125

QC Memo 0.00

Quality Control 2 14-10-28

Work Order ID 121488

September-16-14 12:37:49 PM

121488

Page 3

Item ID: D4297-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 6/26/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

PDD 121701

2

DAS
08
9-89

OCT 31 2014

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

14/11/3

14-1003

Picklist Print

Thursday, June 26, 2014 3:01:19 PM

Page 1

Work Order ID: 121488

121488

Parent Item: D4297-1

D4297-1

Parent Item Name: Bearpaw

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased			No		sf	545.9000		8			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

C. 8/14/10/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	172.6	
m129293	172.6	
MAT018	373.3	
m128267	47	
m128668	326.3	

m130421

x8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

DART AEROSPACE LTD		Work Order:	121488
Description: Bearpaw		Part Number:	D4297-1
Inspection Dwg: D4297 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063x45°	✓		depth G	JFC-07
B 5.500	+/-0.030	5.502	✓		Caliper	JFC-01
C 0.75	+/-0.030	0.750	✓		"	"
D 0.25 x 45°	+/-0.030	0.25x45°	✓		depth G	JFC-07
E R0.250	+/-0.030	R0.250	✓		rad G	Stop
G 0.63	+/-0.030	0.630	✓		Caliper	JFC-01
H 0.38	+/-0.010	0.390	✓		"	"
I 0.950	+0.030/0.010	0.957	✓		"	"
J 19.000	+/-0.030	19.00	✓		tape	JFC-06
K 3.14	+/-0.030	3.14	✓		Caliper	JFC-01
0.200	+/-0.03	0.197	✓		"	"
M Ø0.260	+0.005/-0.000	0.260	✓		"	"
N Ø0.93	+/-0.030	0.928	✓		Caliper	JFC-01
O 0.30	+0.030/-0.000	0.330	✓		depth G	SL-11
P 23.750	+/-0.030	23.75	✓		tape	JFC-06
Q 7.375	+/-0.030	7.375	✓		Caliper	JFC-01
R 4.250	+/-0.010	4.250	✓		"	"
S 2.000	+/-0.030	2.000	✓		"	"
T 9.000	+/-0.010	9.00	✓		"	CNC-02
U 9.000	+/-0.010	9.00	✓		"	CNC-02

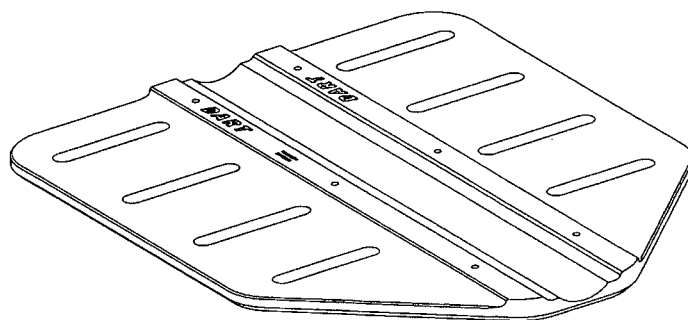
Measured by: JFC	Audited by: JL	Preliminary Approval:
Date: 2014-10-28	Date: 17-10-28	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue P/O D350-578-013	KJ	
B	12.02.01	Dwg Rev updated	KJ	
C	12.07.31	Dwg Rev updated	KJ	

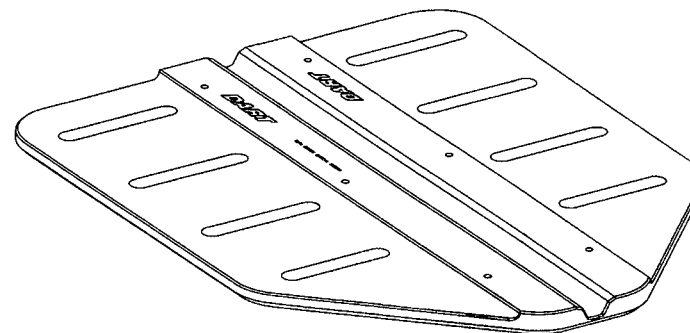
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 121488 MLS

14-06-27



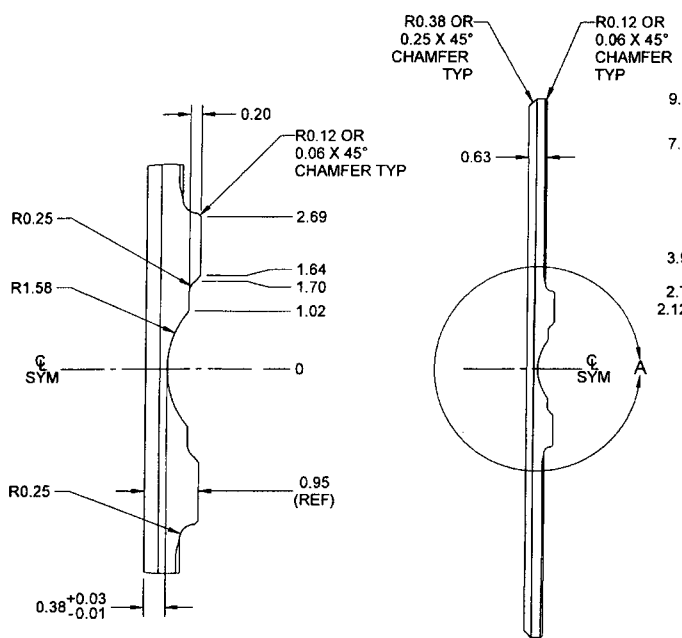
D4297-1 BEARPAW



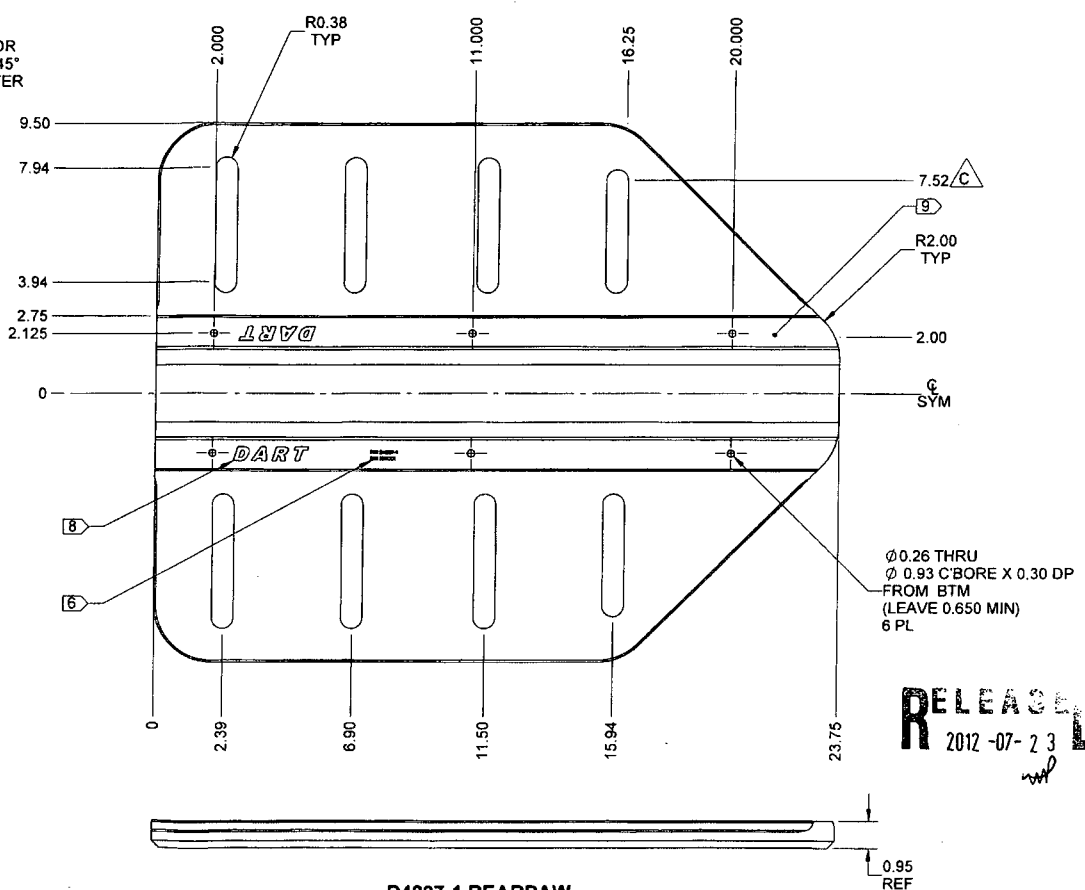
C D4297-3 BEARPAW

RELEASED
2012-07-23
wmp

C	REVISED DRAWING FORMAT, ADDED D4297-3; ADDED DIMENSION 7.52 (D1-2)	AP	12.07.13
B	BOTTOM CHAMFER CHANGED FROM 0.125" TO 0.250", ZN B8-2; TOP CHAMFER CHANGED FROM .125" TO 0.062", ZN C8-2 (REF PAR 11-80)	XDF	11.10.25
A	NEW ISSUE	RF	10.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DT	D4297	SHEET 1 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	BEARPAW	NTS
DATE	12.07.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL A
SCALE 2X



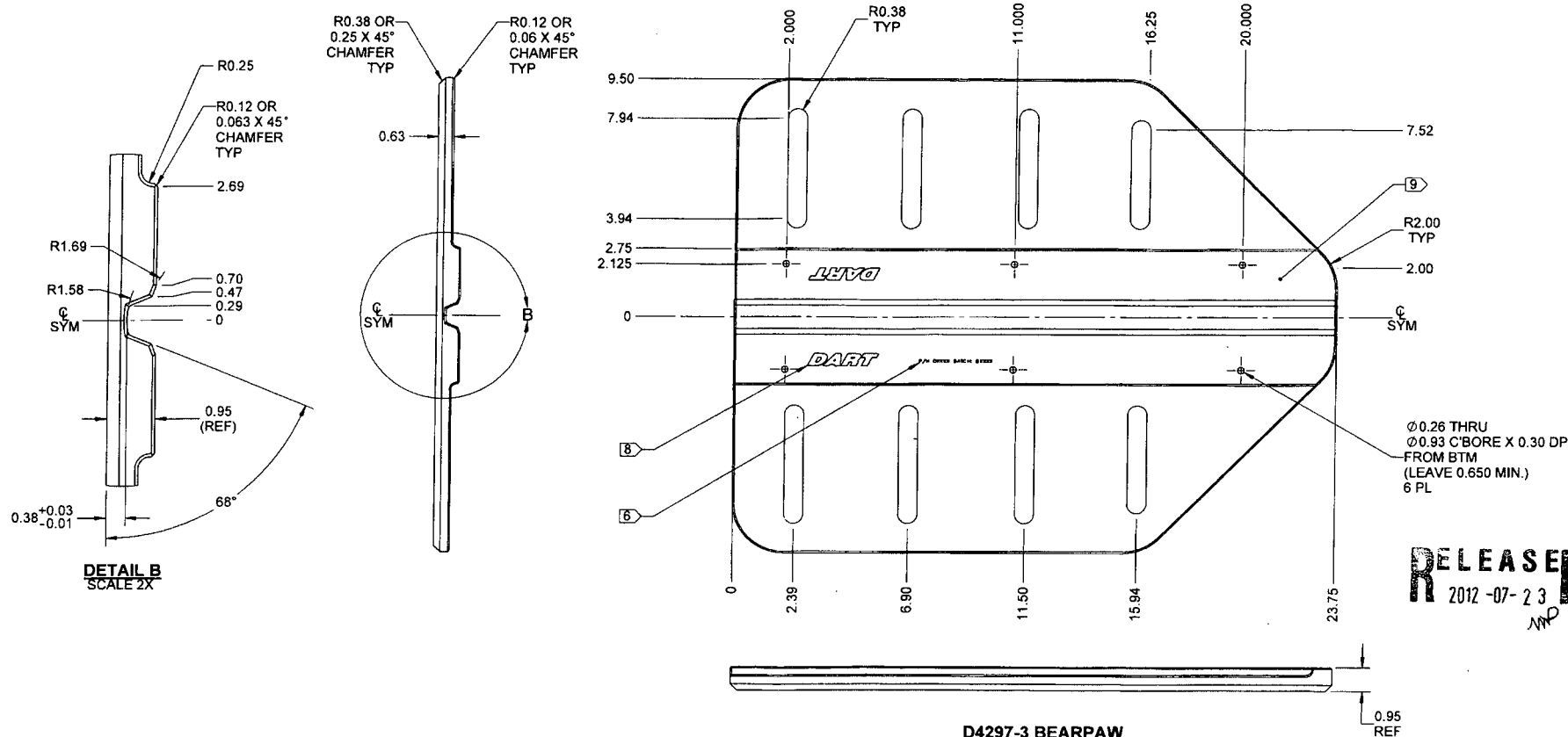
D4297-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D4297-1" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 8.18 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D4297-1-REVC.STP"

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>ALS</i>	DRAWING NO. D4297	REV. C
MFG. APPR.	<i>at</i>		SHEET 2 OF 3
APPROVED	<i>at</i>	TITLE BEARPAW	SCALE NTS
DE APPR.	<i>at</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.07.13		

RELEASE
2012-07-23



RELEASED
2012-07-23

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D4297-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 8.67 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D4297-3-REVC.STP"

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AT	D4297	SHEET 3 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BEARPAW	NTS
DATE	12.07.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6316
Date: 2014-09-29
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2
		po 25636	
Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			